



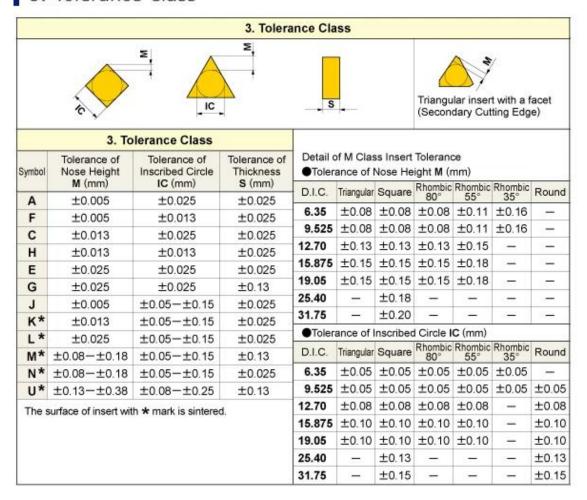
## 1. Insert Shape

1. Insert Shape					
Symbol	Insert Shape				
Н	Hexagonal				
0	Octagonal				
Р	Pentagonal				
S	Square				
Т	Triangular				
С	Rhombic 80°				
D	Rhombic 55°				
E	Rhombic 75°				
F	Rhombic 50°				
М	Rhombic 86°				
V	Rhombic 35°	0			
w	Trigon				
L	Rectangular				
Α	Parallelogram 85°				
В	Parallelogram 82°				
к	Parallelogram 55°				
R	Round	0			
х	Special Design	_			

#### 2. Relief Angle

	2. Relief	Angle			
ymbol	Normal Clearance				
Α	3°	V			
В	5°	V			
С	7°	V			
D	15°	V			
E	20°	V			
F	25°	V			
G	30°	V			
N	0°	L.			
Р	11°	V			
0	Other Re	lief Angle			

#### 3. Tolerance Class



#### 4. Chipbreaker and Clamping System

			4.	Chipbreaker a	ind CI	amping S	System			
Metric										
Symbol	Hole	Hole Configuration	Chip Breaker	Figure	Symbol	Hole	Hole Configuration	Chip Breaker	Figure	
w	With Hole	Cylindrical Hole	No		Α	With Hole	Cylindrical Hole	No		
Т	With Hole	One Countersink (40-60°)	One Sided		М	With Hole	Cylindrical Hole	Single Sided		
Q	With Hole	Cylindrical Hole	No		G	With Hole	Cylindrical Hole	Double Sided		
U	With Hole	Double Countersink (40—60°)	Double Sided		N	Without Hole	<del>m</del> s	No		
В	With Hole	Cylindrical Hole	No		R	Without Hole	<del></del>	Single Sided		
н	With Hole	One Countersink (70-90°)	One Sided		F	Without Hole	5-0	Double Sided		
С	With Hole	Cylindrical Hole	No		х	===	-	-	Special Design	
J	With Hole	Double Countersink (70—90°)	Double Sided							

#### 5. Insert Size

#### 6. Insert Thickness

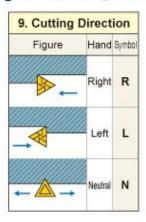
			5. Ins	ert Size				6. Inser	t Thickness
			Symbol				Diameter of	A 400 M 400	100000000000000000000000000000000000000
R	<u>@</u>	V	D	(C)	5	A	Inscribed Circle (mm)		•
	02		04	03	03	06	3.97		. \
	L3	08	05	04	04	08	4.76	*Thickness is from	n the bottom of the inser
	03	09	06	05	05	09	5.56	to the top of the	cutting edge.
06							6.00	Symbol	Thickness (mm)
	04	11	07	06	06	11	6.35		4.00
	05	13	09	08	07	13	7.94	S1	1.39
80							8.00	01	1.59
09	06	16	11	09	09	16	9.525	T0	1.79
10							10.00	100000	1000
12							12.00	02	2.38
12	08	22	15	12	12	22	12.70	T2	2.78
15	10		19	16	15	27	15.875	03	2.10
16							16.00	03	3.18
19	13		23	19	19	33	19.05	T3	3.97
20							20.00	04	4.76
			27	22	22	38	22.225	(7.3)	150,510,75
25							25.00	06	6.35
25			31	25	25	44	25.40	07	7.94
31			38	32	31	54	31.75	090919	0.50
32							32.00	09	9.52

# 7. Insert Corner Configuration 8. Cutting Edge Condition

7. Insert Corn	er Configuration
Symbol	Corner Radius (mm)
00	Sharp Nose
V3	0.03
V5	0.05
01	0.1
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
20	2.0
24	2.4
28	2.8
32	3.2
00 : Inch M0 : Metric	Round Insert

Figure	Cutting Edge	Symbo
	Sharp Cutting Edges	F
	Round Cutting Edges	E
	Chamfered Cutting Edges	т
	Chamfered and Rounded Cutting Edges	s

## 9. Cutting Direction



## 10. Chip Breaker

LP	MP	RP
		<b>A</b>
LM	MM	RM
LK	MK	RK
6	<u> </u>	0
LS	MS	RS
0	0	9
FP	LP	MP
MA	sw	MW
0		
HZ	нх	HV